



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-698-013
Job Sheet 186476



Part No: D412-698-013

Job Qty: 1 ea

Part Name: Cabin Door Handle - Aluminum Door



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev: C Removed Manufacturing 05-11-06 JLM IPP Rev:D change to rev D ECN
1104 08-01-28 DD

Ship Via:

6629

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/6/18	12/6/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 22 2018
110	Packaging	1 pcs	12/6/18	12/6/18	0.00	0.00	Packaging1-4		NOV 28 2018
120	QC	1 pcs	12/6/18	12/6/18	0.00	0.00	QC4		
130	Packaging	1 pcs	12/6/18	12/6/18	0.00	0.00	Packaging3-2		
135	DC	1 pcs	12/6/18	12/6/18	0.00	0.00	DC		
140	QC21-FG	1 Ea	12/6/18	12/6/18	0.00	0.00	QC21		

Part Op Descriptions: 135 - Photocopy bluefile and create labels per PPP D412-698-013 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3203-1	Handle	4 Ea (4 ea)	90-Start up Operation	S120067
D3220-041	Doubler Assembly	1 Ea (1 ea)	90-Start up Operation	S114828
D3220-042	Doubler Assembly	1 Ea (1 ea)	90-Start up Operation	S1207310
D3220-3	Doubler	2 Ea (2 ea)	90-Start up Operation	S114825
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	S109736
MS24694-S98	Screw	16 Ea (16 ea)	90-Start up Operation	S057536
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	S130457

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3203-1	4	5	0
	D3220-041	1	9	0
	D3220-042	1	0	0
	D3220-3	2	4	0
	MS21042L4	8	1,888	0
	MS24694-S98	16	61	0
	NAS1149D0463J	8	2,662	0

Part Specifications

Specifications could not be found.



Work Order update only

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/ ☐ Large Fab ☐ Composite ☐					
Part No. _____									
NCR No. _____									
Date :		Step #:		QTY Effective :					
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Lo. ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Crushing ☐ Countersink ☐ Off-set ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐					
OTHER :									

REFERENCE ONLY

6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

REFERENCE ONLY

REFERENCE ONLY

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G

Date: 17.11.23

REFERENCE ONLY

REFERENCE ONLY

Change Record

PAGE 1 OF 1

Part Number: D412-698-013

Description: DOOR HANDLE INSTALLATION

[illegible]

